

Work Order ID 69493

Wednesday, May 11, 2011 12:58:20 PM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: M115778 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

11.06.07

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.06.07

W/O:		WORK ORDER CHANGES					
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Required Date:	5/13/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
130 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 8-15 Oven Temperature: 320 OF Finish Time: 8-45	0.00 0.00							
140 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00 0.00							

IX M-11/06/08

1 11-6-8.

M116128

M117315.

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Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: 11/06/08

160

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

Handwritten: GA w/o 69487

Handwritten: 11/06/08

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten: 11/06/08 ME 11-06-08

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Picklist Print

Wednesday, May 11, 2011 12:58:27 PM

Page 1

Work Order ID: 69493

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011




Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	38.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>38</div> <div></div> </div>													
<div> <div>68964</div> <div>38</div> <div></div> </div>													
D3914-1  Rib		Manufactured	No			100	Each	2.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>2</div> <div></div> </div>													
<div> <div>369065</div> <div>2</div> <div></div> </div>													
<div> <div>69087</div> <div>2</div> <div></div> </div>													
D3914-7  Rib		Manufactured	No			100	Each	8.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>4</div> <div></div> </div>													
<div> <div>69277</div> <div>4</div> <div></div> </div>													
<div> <div>WA006</div> <div>4</div> <div></div> </div>													
<div> <div>68175</div> <div>4</div> <div></div> </div>													

SAD 11-06-07

2

SAD 11-06-07

2

SAD 11-06-07

2

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Work Order ID: 69493

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3
Hinge Half, Lid

Manufactured No

100 Each

9.0000

3 3



SAD 11-06-03

Location Loc Qty Loc Code

ST109 B69164 6

68512 6

WA005 3

67040 3

3

D4018-5
Rib

Manufactured No

100 Each

37.0000

9 9



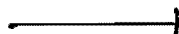
SAD 11-06-03

Location Loc Qty Loc Code

WA005 B69726 37

67041 14

69013 23



9

D4020-5
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each

2.0000

1 1



SAD 11-06-03

Location Loc Qty Loc Code

WA B69293 2

68234 2

1

D4021-3
Data Plate

Manufactured No

100 Each

3.0000

1 1



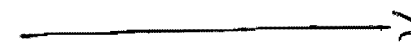
SAD 11-06-03

Location Loc Qty Loc Code

WA005 3

66721 3

B69724



1

Wednesday, May 11, 2011 12:58:28 PM

Shop Packet Print

Page 2

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Picklist Print

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Page 3

Work Order ID: 69493

Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 5/11/2011



Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041	Manufactured	No	100	Each	4.0000	1	1
							SAJ 11-06-03
Lid Rib Assembly, Fwd (350 Basket)							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			WA006	4			
			67374	4			
D4035-043	Manufactured	No		100	Each	6.0000	1
							① SAJ 11-06-03
Lid Rib Assembly, Aft (350 Basket)							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			WA006	6			
			67375	6			
D2728-3	Manufactured	No		140	Each	0.0000	1
							① M115050
Dart Logo label							

JS 11/06/08

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4018-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69493

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. B TITLE LONG BASKET LID ASSY (350) SCALE NTS SHEET 1 OF 4 COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES FOR WHICH IT WAS NOT DESIGNED OR FOR WHICH IT WAS NOT SPECIFICALLY DESIGNED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

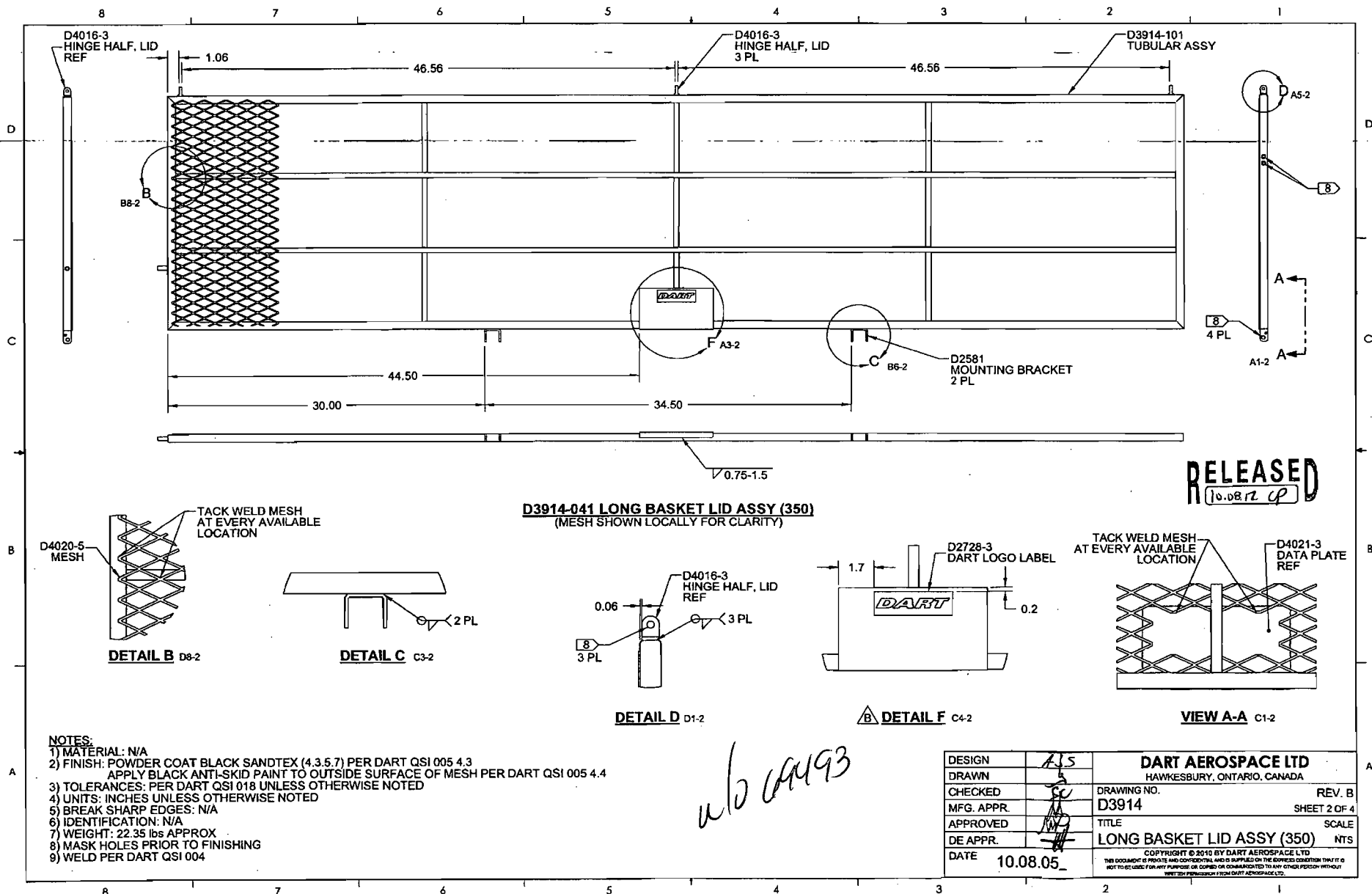
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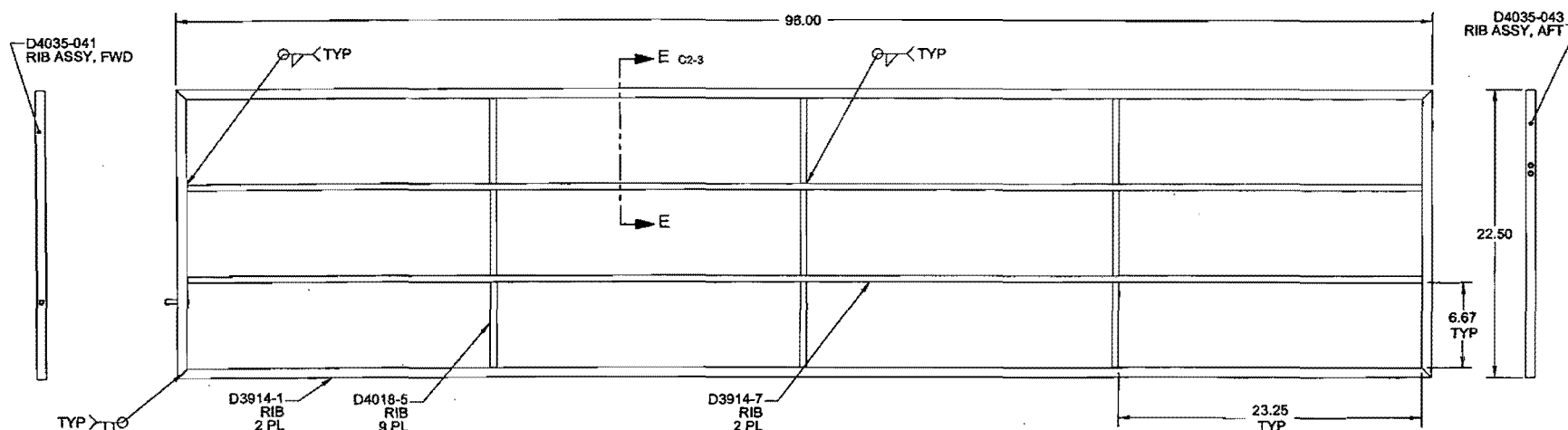
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



RELEASED
10-08-12 CP

8 D3914-101 TUBULAR ASSY, LONG LID

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

WLB 69493

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	RC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RC	DRAWING NO.	REV. B
MFG. APPR.	RC	D3914	SHEET 3 OF 4
APPROVED	RC	TITLE	SCALE
DE APPR.	RC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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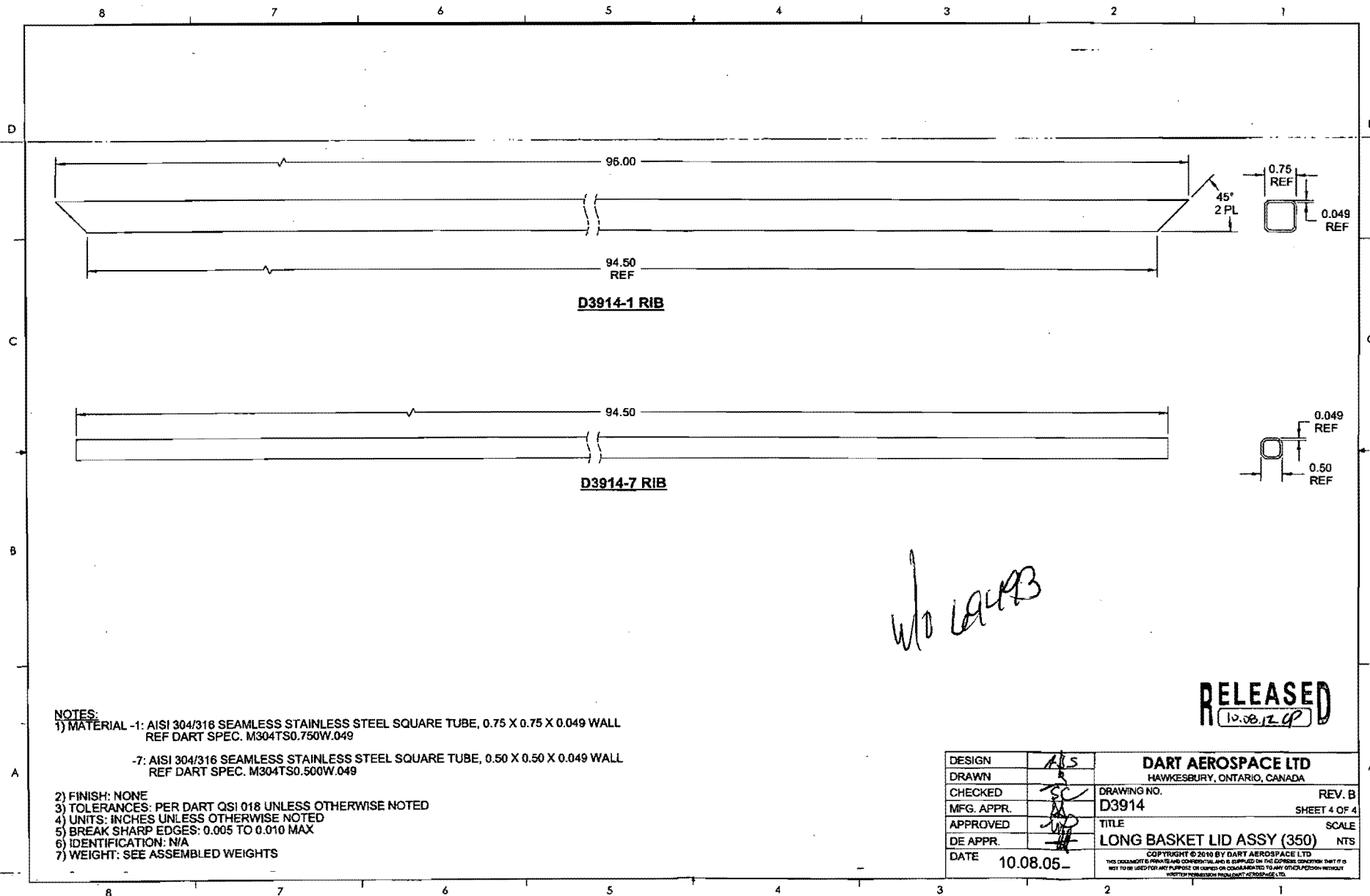
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